

Work Order ID 55491

January 19, 2010 1:37:03 PM



Page 1

Item ID: D3589-047

Revision ID:

Item Name: FWD GUIDE

Start Date: 1/19/10 Start Qty: 4.00

Required Date: 1/25/10 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3589

Rev B

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 1108/60 0.00

Memo 0.00

1- assemble and weld as per dwg D3589 QSI004

A/R Stainless Steel rod batch:

EL 10-3-15 (x4)

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo 0.00

DD 10.03-15 (4)

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo 0.00

Sw 10/3/23

(x4)

Work Order ID 55491

January 19, 2010 1:37:03 PM



Page 2

Item ID: D3589-047

Accept



Setup Start



Revision ID:

Stop



Item Name: FWD GUIDE

Start Date: 1/19/10 Start Qty: 4.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: *store*

0.00

Memo

0.00

Pa 10/3/23 (4)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/03/24 JJ**Pl 10-3-23 (4)*

Picklist Print

January 19, 2010 1:37:08 PM

Page 1

Work Order ID: 55491

Parent Item: D3589-047

Parent Item Name: FWD GUIDE


Comments: IPP Rev:A 08-05-30 new issue DD verified by:cc

Start Date: 1/19/10

Required Date: 1/25/10

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| D3589-17  FWD GUIDE PLATE | | Manufactured | No | | | 100 | Each | 3.0000 | 4.0000 | | | |

EL 10-3-15

B55624 → 1

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| ST | 3 | |
| 45011 | 3 | |

3

D3589-5



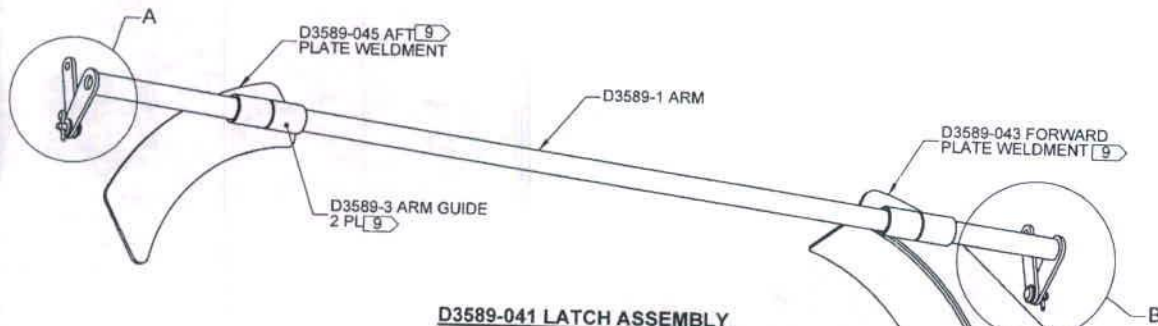
LATCH GUIDE

Manufactured No

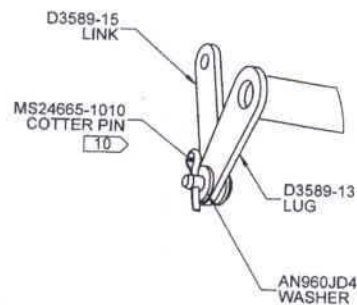
100 Each 0.0000 4.0000

EL 10-3-15

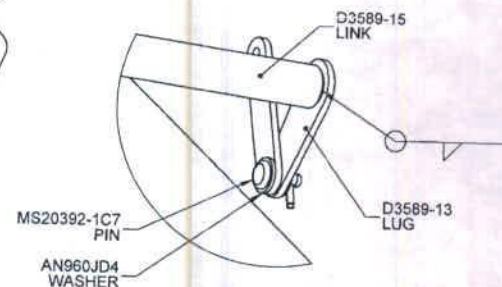
55625 x 4



D3589-041 LATCH ASSEMBLY



DETAIL A: LINK ASSEMBLY DETAIL
SCALE 2X
2 PL



**DETAIL B: WELDING AND
LINK ASSEMBLY DETAIL**
SCALE 2X
2 PL

| QTY. -041 | P/N | DESCRIPTION |
|--------------|--------------|------------------------|
| X | D3589-041 | LATCH ASSEMBLY |
| 1 | D3589-045 | AFT PLATE WELDMENT |
| 1 | D3589-043 | FORWARD PLATE WELDMENT |
| 1 | D3589-1 | ARM |
| 2 | D3589-3 | ARM GUIDE |
| 2 | D3589-13 | LUG |
| 2 | D3589-15 | LINK |
| 4 | AN960JD4 | WASHER |
| 2 | MS20392-1C7 | PIN |
| 2 | MS24665-1010 | COTTER PIN |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35491
B/10-1-19

- D3589-041 NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs
 - 8) WELDING: PER DART QSI 004 USING DT9033
 - 9) IDENTIFIED PARTS ARE LOOSE ON D3589-1 ARM
 - 10) INSTALL COTTER PIN IN ACCORDANCE WITH MS33540

RELEASED
9/62/05/WP

| | | | |
|------------|---|----|----------|
| B | 0.80 AND 0.63 REF WERE 1.97 AND 0.60 (ZN C6-2); 0.50 WAS 1.89 (ZN C3-2); 0.75 REF REPLACES 2.01 (ZN C2-2); 29" WAS 15" (ZN B2-2); 19.00 WAS 18.88 (ZN D4-4); REDESIGNED D3589-9 (ZN A6-6) AND D3589-11F (ZN C2-3) REASON: REDESIGN FOR PROPER FIT AND TO MATCH TESTED CONFIGURATION | MB | 08.06.25 |
| A | NEW ISSUE | MB | 08.05.29 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | J | | |
| DRAWN | J | | |
| CHECKED | J | | |
| MFG. APPR. | J | | |
| APPROVED | J | | |
| DE APPR. | J | | |
| DATE | 08.06.25 | | |

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HAWKESBURY, ONTARIO, CANADA

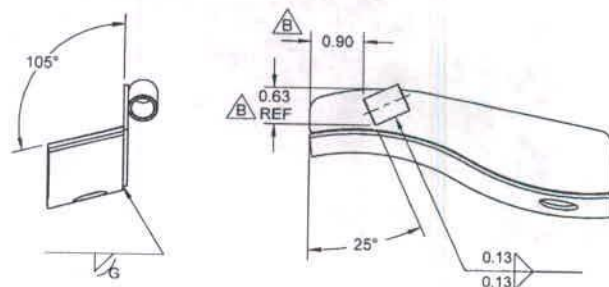
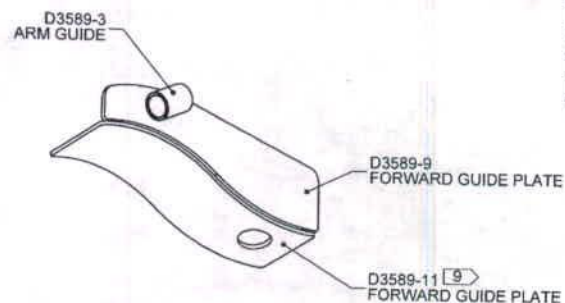
DRAWING NO. **D3589** REV. B
SHEET 1 OF 8

TITLE **LATCH ASSEMBLY** SCALE NTS

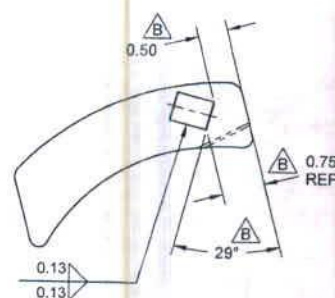
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| QTY -043 | QTY -045 | P/N | DESCRIPTION |
|-------------|-------------|-----------|------------------------|
| X | | D3589-043 | FORWARD PLATE WELDMENT |
| | X | D3589-045 | AFT PLATE WELDMENT |
| 1 | 1 | D3589-3 | ARM GUIDE |
| 1 | 1 | D3589-7 | AFT GUIDE PLATE |
| 1 | | D3589-9 | FORWARD GUIDE PLATE |
| 1 | | D3589-11 | FORWARD GUIDE PLATE |



D3589-043 FORWARD PLATE WELDMENT



D3589-045 AFT PLATE WELDMENT

D3589-043/-045 NOTES:

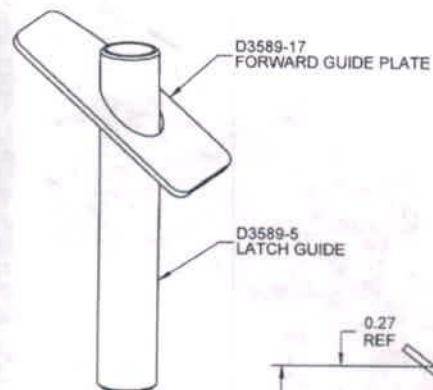
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D3589-043 = 0.22 lbs
 - D3589-045 = 0.10 lbs
- 8) WELDING: PER DART QSI 004 USING DT9033
- 9) FORM D3589-11 TO FIT D3589-9 MATING EDGE

RELEASED
09/02/05 N/A

| | | | |
|-----------|----------|--|--------------|
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG APPR. | | D3589 | SHEET 2 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LATCH ASSEMBLY | NTS |
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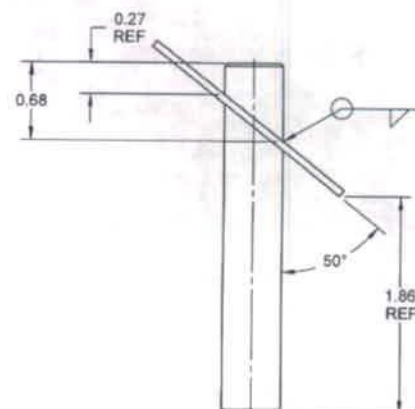
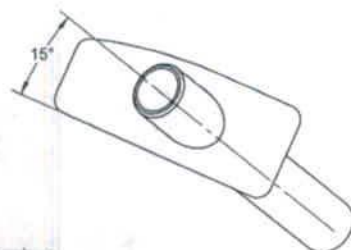
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| QTY -047 | QTY -049 | P/N | DESCRIPTION |
|-------------|-------------|-----------|---------------------|
| X | | D3589-047 | FORWARD GUIDE |
| | X | D3589-049 | AFT GUIDE |
| 1 | 1 | D3589-5 | LATCH GUIDE |
| 1 | | D3589-17 | FORWARD GUIDE PLATE |
| | 1 | D3589-19 | AFT GUIDE PLATE |



D3589-17
FORWARD GUIDE PLATE

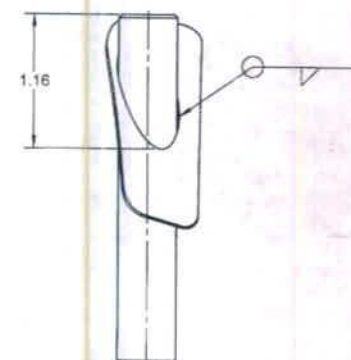
D3589-5
LATCH GUIDE



D3589-047 FORWARD GUIDE

D3589-19
AFT GUIDE PLATE

D3589-5
LATCH GUIDE



D3589-049 AFT GUIDE

D3589-047/-049 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3589-0XX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs EACH
- 8) WELDING: PER DART QSI 004

| | | | | |
|------------|---|--|--|--------------|
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| DRAWN |  | | | |
| CHECKED |  | | DRAWING NO. | REV. I |
| MFG. APPR. |  | | D3589 | SHEET 3 OF 8 |
| APPROVED |  | | TITLE | SCALE |
| DE APPR. |  | | LATCH ASSEMBLY | NTS |
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RELEASED
8/2/08

w/o 55491

Ø 0.375
REF

0.03 X 45°
CHAMFER
2 PL

0.065
REF

19.00

D3589-1 ARM

Ø 0.500
REF

0.058
REF

0.65

D3589-3 ARM GUIDE

Ø 0.500
REF

0.03 X 45°
CHAMFER
2 PL

0.049
REF

3.00

D3589-5 LATCH GUIDE

D3589-1/-3/-5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

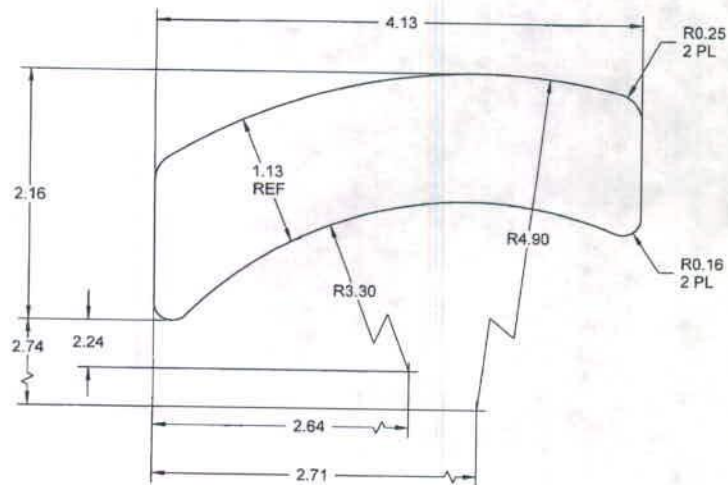
7) WEIGHT: - D3589-1 = 0.34 lbs
- D3589-3 = 0.01 lbs
- D3589-5 = 0.06 lbs

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9/6/05

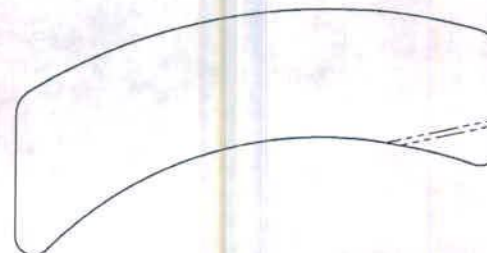
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| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3589 | SHEET 4 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LATCH ASSEMBLY | NTS |
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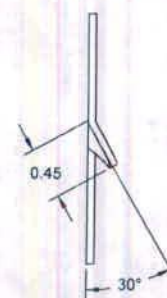




**D3589-7F AFT GUIDE PLATE
FLAT PATTERN**



**D3589-7 AFT GUIDE PLATE
MAKE FROM D3589-7F**



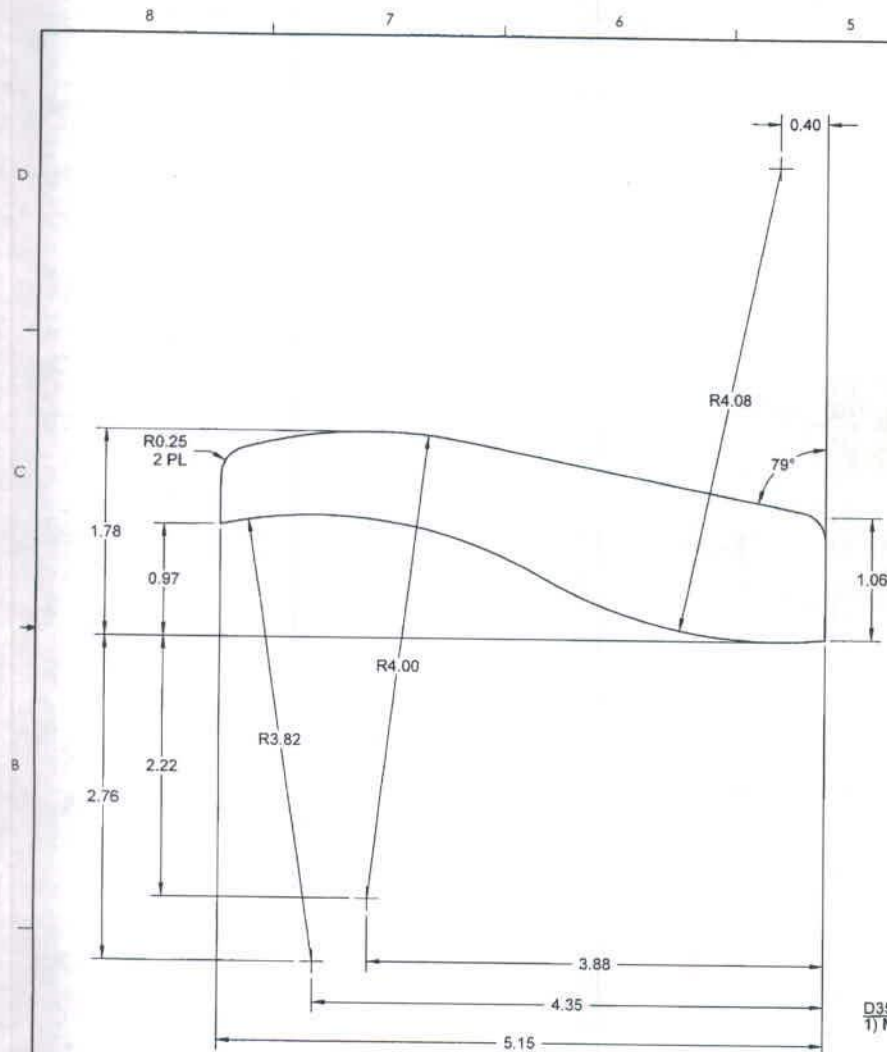
D3589-7F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

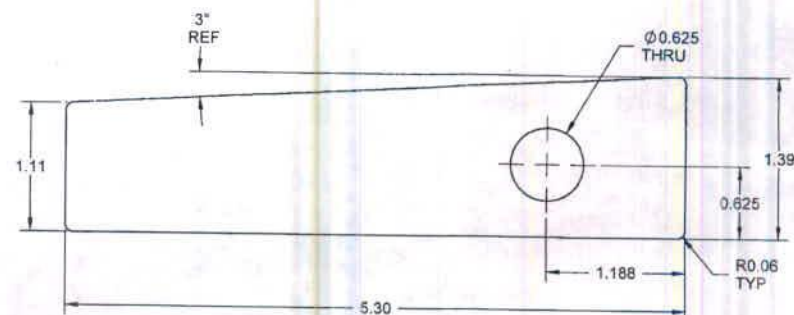
| | | | | |
|--|--------------------|--|----------------|--------------|
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | <i>[Signature]</i> | | | |
| CHECKED | <i>[Signature]</i> | | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | | D3589 | SHEET 5 OF 8 |
| APPROVED | <i>[Signature]</i> | | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | | LATCH ASSEMBLY | NTS |
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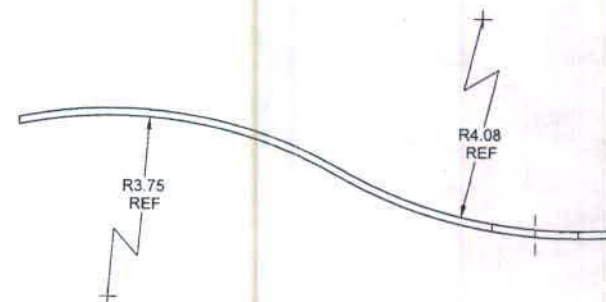
W10 55491



D3589-9 FORWARD GUIDE PLATE



D3589-11F FORWARD GUIDE PLATE
FLAT PATTERN



D3589-11 FORWARD GUIDE PLATE
(MAKE FROM D3589-11F)

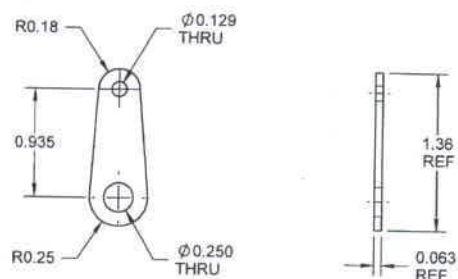
D3589-9/-11/-11F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET,
PER AMS 5513 OR AMS 5524,
OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK).
(REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 LBS EACH
- 8) CONTROL SHAPE PER DT9021 TEMPLATE

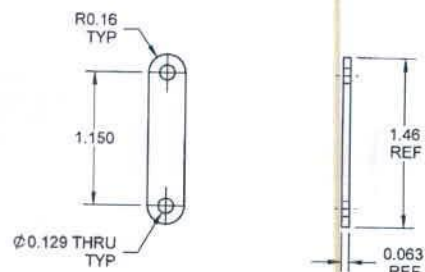
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09/02/03

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| | | | |
|------------|----------|---|--------------|
| DESIGN | | DRAWING NO. | REV. B |
| DRAWN | | D3589 | SHEET 6 OF 8 |
| CHECKED | | | SCALE |
| MFG. APPR. | | | NTS |
| APPROVED | | TITLE | |
| DE APPR. | | FORWARD GUIDE PLATE | |
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D3589-13 LUG



D3589-15 LINK

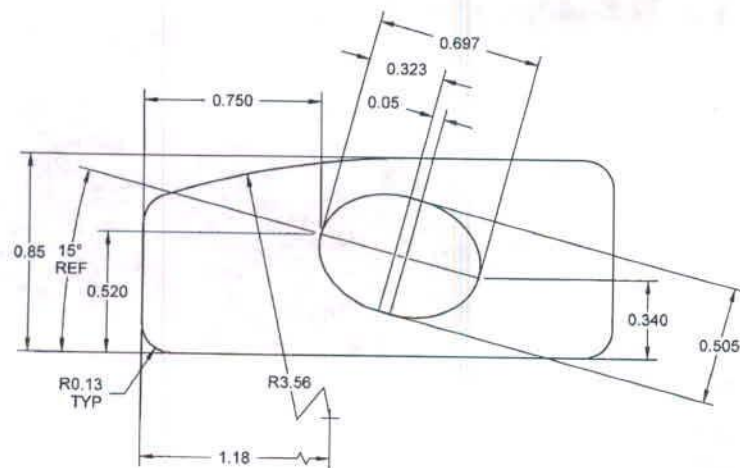
D3589-13/-15 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH
16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs EACH

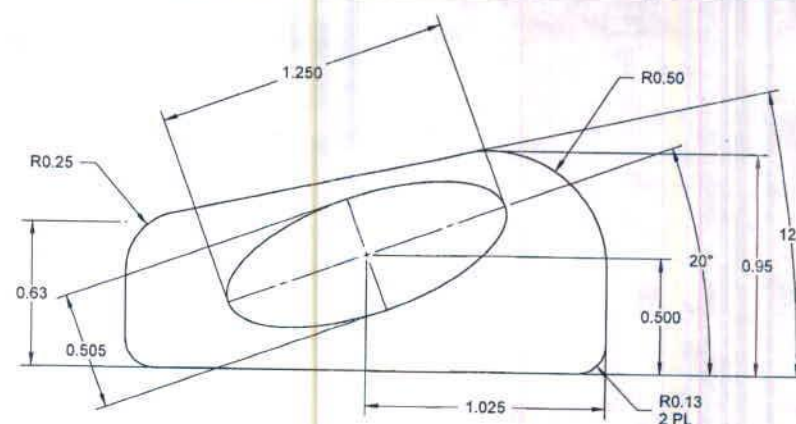
| | | | |
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| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D3589 | SHEET 7 OF 8 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | LATCH ASSEMBLY | NTS |
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07/02/05

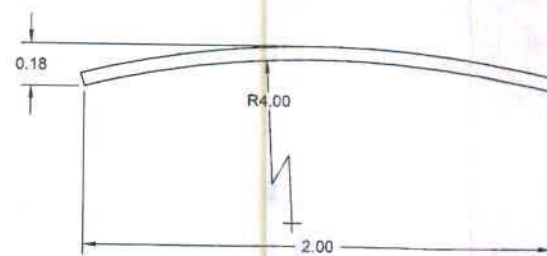
111055491



D3589-17 FORWARD GUIDE PLATE



D3589-19F AFT GUIDE PLATE FLAT PATTERN



D3589-19 AFT GUIDE PLATE
(MAKE FROM D3589-19F)

D3589-17/-19/-19F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, PER AMS 5513 OR AMS 5524, OR MIL-S-5059 (ANNEALED) 2B FINISH 16 GAUGE (0.063 THICK), (REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs EACH

| | | |
|------------|----------|---|
| DESIGN | 14 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3589 TITLE LATCH ASSEMBLY SCALE NTS |
| DRAWN | 14 | |
| CHECKED | PH | |
| MFG. APPR. | 14 | |
| APPROVED | 14 | |
| DE APPR. | 14 | |
| DATE | 08.06.25 | |

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09/02/05/11/14

W1055491

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